

# Work Order ID 80162

February-13-12 8:56:29 AM

**\*80162\***

Page 1

Item ID: D2873-045 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Nut Plate Assembly  
 Start Date: 13/02/2012 Start Qty: 20.00 **\*20\*** Cust Item ID:  
 Required Date: 27/02/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
 Reference:

Approvals: Process Plan: M.C.J. Date: 12/02/13 Tooling: Date: Run Start **\*NR1\***  
 QC: Date: SPC (Y/N): Date: Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2873	Rev A

100	BAND SAW	0.00							
<b>*100*</b>									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 1.000" x 0.375" x 2.700" long		<u>JK</u>	<u>12/03/08</u>		<u>20</u>	<u>0</u>		

110	HAAS CNC VERTICAL MACHINING #1	0.00							
<b>*110*</b>									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio FA and Dwg D2873 Identify as D2873-5 Dwg Rev <u>A</u> F1819Folio Rev <u>AA</u>		<u>PO/R</u>	<u>12/03/10</u>		<u>20</u>	<u>0</u>		

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control			<u>PO/R</u>	<u>12/03/10</u>		<u>20</u>	<u>0</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Page 2

Item ID: D2873-045 Accept **\*N900040100\*** Setup Start **\*NS1\***  
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Required Date: 27/02/2012 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC8- Inspect parts - second check	0.00							
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**\*130\***

QC

Memo

0.00

Quality Control

D.A 12/03/11

20

φ

140

0.00

**\*140\***

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr 2- C'sink as per Dwg D2873

12/03/12 20

150

0.00

**\*150\***

QC

Memo

0.00

Quality Control

QC5- Inspect part completeness to step on W/O

12/03/12

conts

20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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# Work-Order ID 80162

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\*80162\*

Page 3

Item  
Revis  
Item  
Start  
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Refer

Item ID: D2873-045

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Nut Plate Assembly

Start Date: 13/02/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 27/02/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Appr

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Seque  
Work  
190  
\*10  
QC  
Quality

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

\*160\*

HandFinish

Memo

0.00

Hand Finishing

20X12/23/12

200  
\*20  
Packa  
Packag

170

QC3- Inspect Part Finish

0.00

\*170\*

QC

Memo

0.00

Quality Control

420 f All 12/23/12

210  
\*20  
QC  
Quality

180

Small Fab

0.00

\*180\*

Small Fab

Memo

0.00

Small Fab

1-Assemble as per Dwg D2873 2-Identify as D2873-045

12/23/12 (20)

Dart

Dart Aerospace Ltd

W/O:

W/O:

## WORK ORDER CHANGES

DAT

DATE

STEP

PROCEDURE CHANGE

By

Date

Qty

Approval  
Chief Eng /  
Prod MgrApproval  
QC Inspector

Part

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR

NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

DAT

DATE

STEP

Description of NC  
Section A

Corrective Action Section B

Initial  
Chief EngAction Description  
Chief EngSign &  
DateVerification  
Section CApproval  
Chief EngApproval  
QC Inspector

NOT

NOTE: Date &amp; initial all entries

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H:\VFORMS\Quality Assurance\approved QAWCRWO RevE

# Picklist Print

February-13-12 8:56:33 AM

Page 1

Work Order ID: 80162

\*80162\*

Parent Item: D2873-045

\*D2873-045\*

Parent Item Name: Nut Plate Assembly

Start Date: 13/02/2012

Required Date: 27/02/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L5		Purchased	No			100	Each	126.0000	2	40			

\*MS21075L5\*

Nut Plate

\*\*

Location	Loc Qty	Loc Code
ST302	100	
120662	100	
ST303	26	
120559	26	

M6061T6B0.375X01.00  
0

Purchased

No

180

f

26.2920

0.225

4.736842

\*M6061T6B0.375X01.000\*

6061T6 BAR .375 x 1.00

\*\*

Location	Loc Qty	Loc Code
MAT001	2.292	
118641	2.292	
MAT002	24	
119346	12	
120603	12	

MS20426AD4-6

Purchased

No

180

Each

2,246.000

4

80

\*MS20426AD4-6\*

Rivet

\*\*

Location	Loc Qty	Loc Code
ST317	2246	
110139	207	
117505	36	
118510	1053	
119436	950	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <i>800000</i>
<b>Description:</b> Radius Block		<b>Part Number:</b> D2873-5
<b>Inspection Dwg:</b> D2873	<b>Rev:</b> A	<b>Page 1 of 1</b>

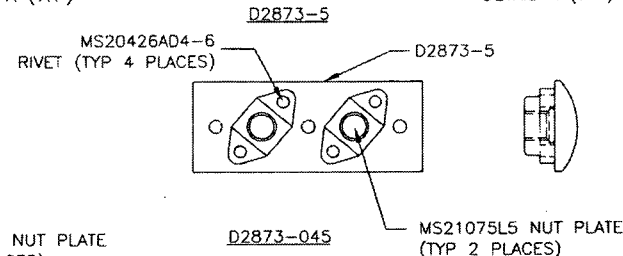
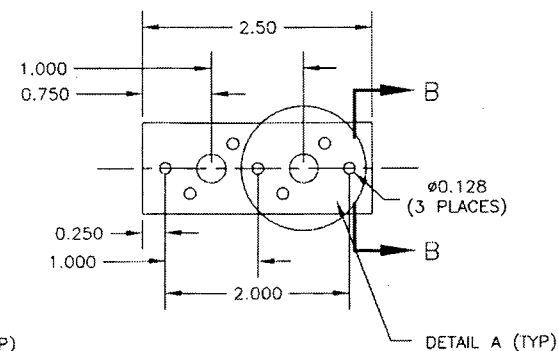
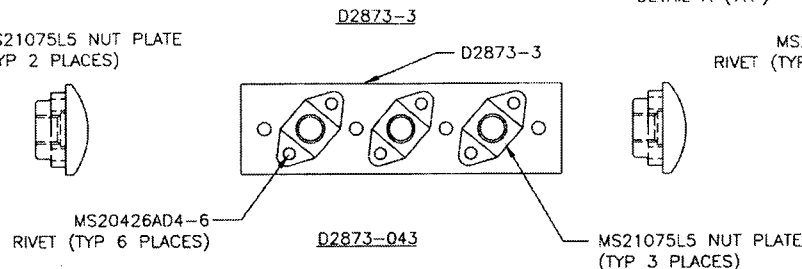
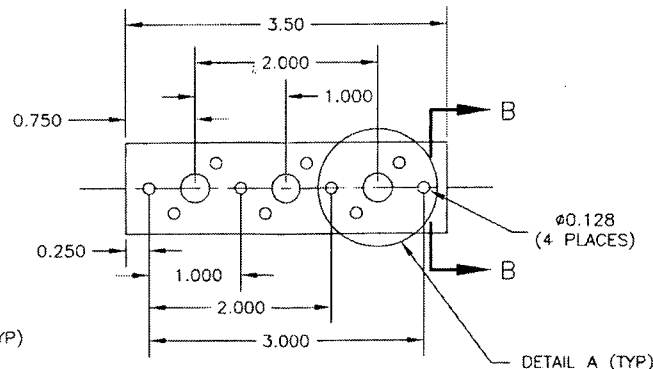
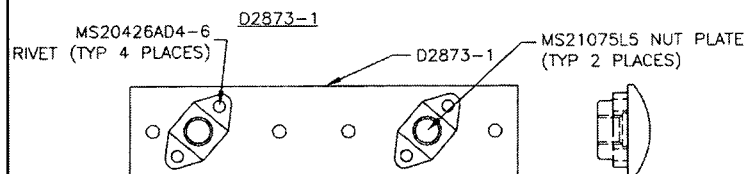
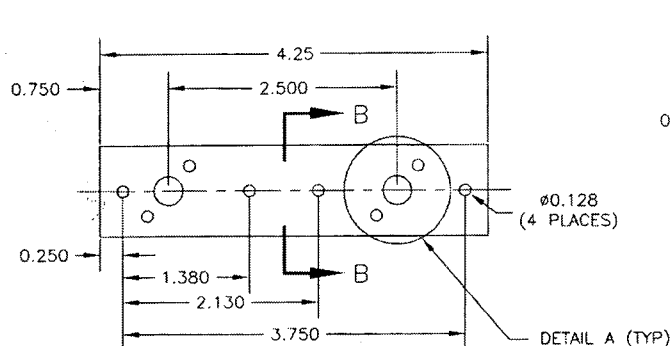
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.50	✓		VERN	ML-06
1.000	+/-0.010	1.000	✓			
0.750	+/-0.010	0.750	✓			
0.250	+/-0.010	0.250	✓			
1.000	+/-0.010	1.000	✓			
2.000	+/-0.010	2.000	✓			
Ø0.128	+0.005/-0.001	0.129	✓			
0.359	+/-0.010	0.359	✓			
Ø0.316	+0.006/-0.001	0.317	✓			
1.000	+/-0.010	1.001	✓			
0.250	+/-0.010	0.249	✓			
0.061	+/-0.010	0.061	✓			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	0.229 x 0.123	✓			

<b>Measured by:</b> <i>PO/R</i>	<b>Audited by:</b> <i>B.A</i>	<b>Prototype Approval:</b> N/A
<b>Date:</b> 12/03/10	<b>Date:</b> 12/03/11	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>



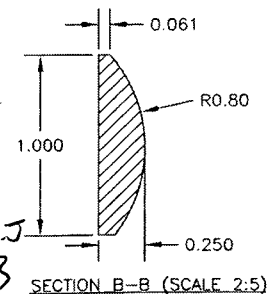
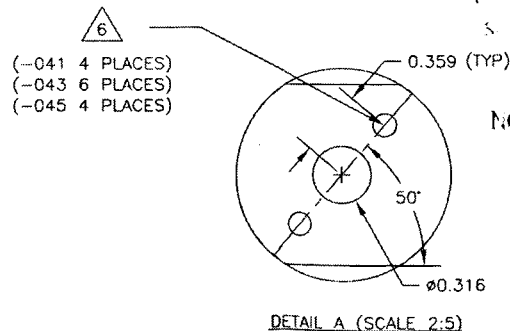
- D2873-1/-3/-5 RADIUS BLOCK**
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X0.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X0.250)
  - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
  - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) ALL DIMENSIONS ARE INCHES
  - 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
  - 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100°

**D2873-041/-043/-045 NUT PLATE ASSEMBLY**

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

**D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST**

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



NO - 80.162 HLCJ  
12/02/13

A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.26	TITLE
		RADIUS BLOCK
		SCALE
		4:5

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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